

Work Order ID 151570***151570***

Page 1

Wednesday, September 28, 2016 4:26:50 PM

Item ID: D4365-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bar Weldment
Start Date: 9/28/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 10/5/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Em Date: 10/09/28 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4365	B

100

0.00

100

Cold Saw

Memo

0.00

Hyd Mech

Cut D4365-1 blanks at 45.00"

extra material will be trim off at assembly

4 Q.L 17-02-15

110

Weld per dwg & QSI004 4.5

0.00

110

autoweld 1

Memo

0.00

Automated Welding 1

1- USE GRINDER TO CHAMFER END AS PER DWG . SEE "DETAIL A"

SEE NOTE 8 FOR SURFACE BUILDUP

FOR AUTOMATED WELDING USE 8259 HARDCOAT

BATCH: M1365514 Q.L/a 17-02-16

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N900040100

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NS1

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NS2

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Start Date: 9/28/2016 Start Qty: 4.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.01

Quality Control

(u)

17-03-02

DAS

9

9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.01

Quality Control

(u)

17-03-02

DAS

9

9-89

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

0.01

Packaging

LOCATION: WA001

4, Q.L

17-03-02

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Wednesday, September 28, 2016 4:26:50 PM

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N900040100

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Item Name: Bar Weldment

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Required Date: 10/5/2016 Req'd Qty: 4.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.07

Quality Control

DAS
21
9-89

MAR 03 2017

Picklist Print

Wednesday, September 28, 2016 4:26:50 PM

Page 1

Work Order ID: 151570

151570

Parent Item: D4365-041

D4365-041

Parent Item Name: Bar Weldment

Start Date: 9/28/2016

Required Date: 10/5/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 15.10.16 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased		No			f	47.8460		15.78947			
✓ *M304B0 250x0 500*									**			Q.L 17-02-15	
304 BAR .250 x .500													

Location

Loc Qty

Loc Code

WA002

47.846

134172

6

m133596

38.948

m133923

1.85

m134526

1.048

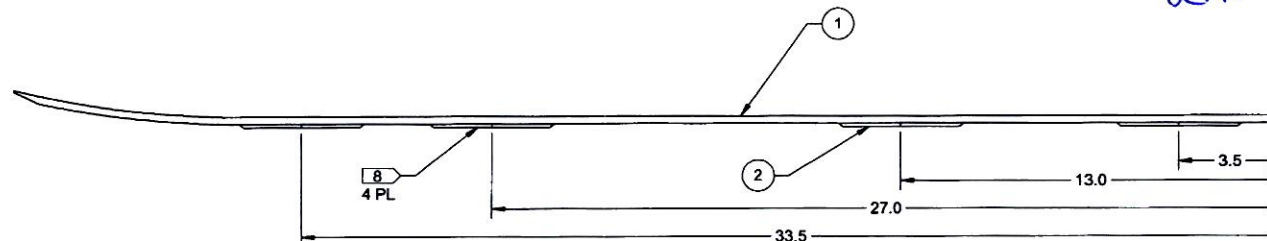
M136163

21,22

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4365-041	BAR WELDMENT
1	1	D4365-1	BAR
2	A/R	8259/2059B	HARD SURFACING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 151570
dem 16/09/28



D4365-041 BAR WELDMENT

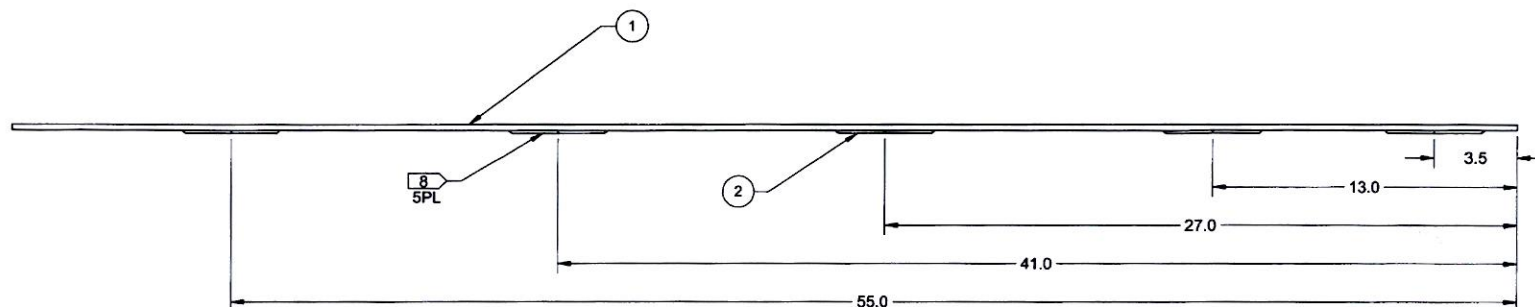
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4365-041 PER QSI 044 6.1
- 7) WEIGHT: D4365-041 = 1.92 lbs
- 8) BUILDUP HARD SURFACING 0.18 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR, BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

B	ADD D4365-041/D43 WELDMENTS, MODIFY D4365-1 (ADD FORMING DETAILS, REMOVE 0.188 HOLES), MODIFY D4365-3 (REMOVE 0.188 HOLES), ADD D4365-1F, ADD AUTOMATED WELDING NOTE		DB	18.05.24
A	NEW ISSUE		SC	11.06.14
REV.	DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR		
DRAWN	DB			
CHECKED	WM	DRAWING NO.		REV. B
MFG. APPR.	DD	D4365		SHEET 1 OF 3
APPROVED	WM	TITLE		SCALE
DE APPR.	DS	WEARBAR		NTS
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RELEASED
2016-06-16
EW 16-574
APPROVED

ITEM	QTY	P/N	DESCRIPTION
	X	D4365-043	BAR WELDMENT
1	1	D4365-3	BAR
2	A/R	8259/2059B	HARD SURFACING



D4365-043 BAR WELDMENT

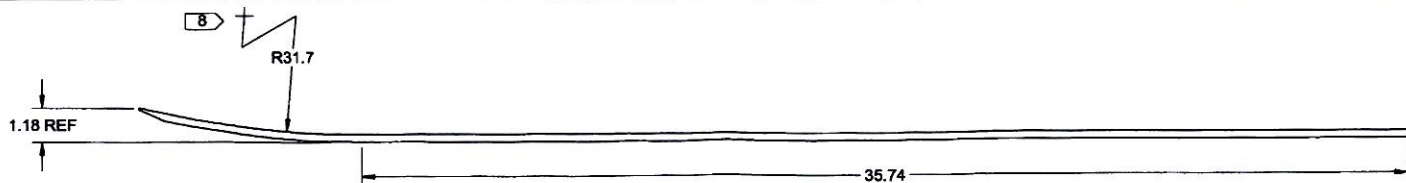
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4365-043 PER QSI 044 6.1
- 7) WEIGHT: D4365-043 = 2.79 lbs
- 8) BUILDUP HARD SURFACING 0.18 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR, BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

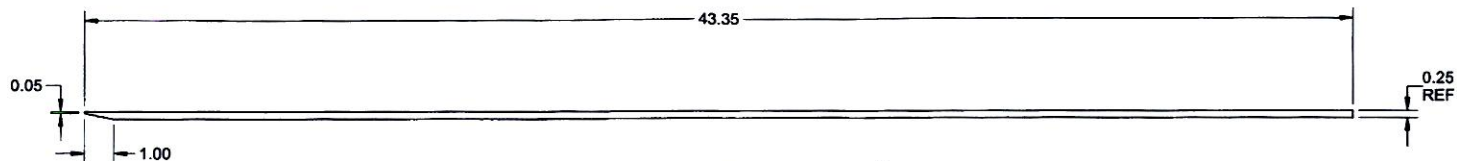
RELEASE
2016-06-16

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	WM	DRAWING NO.	REV. E
MFG. APPR.	DD	D4365	SHEET 2 OF 3
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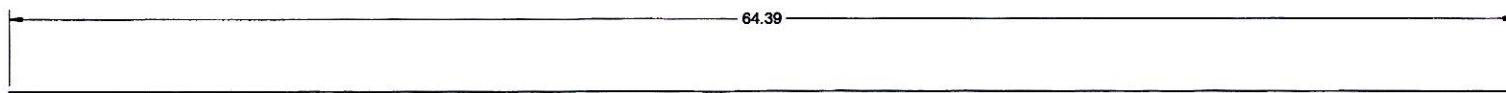
8 7 6 5 4 3 2 1



D4365-1 BAR
(MAKE FROM D4365-1F) $\triangle B$



D4365-1F FLAT BAR $\triangle B$



D4365-3 BAR $\triangle B$

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR. 0.250 THICK X 0.500 WIDE
PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4365-1 = 1.28 lbs, D4365-3 = 1.98 lbs
- 8) FORM TO FIT WEARPLATE AT NEXT ASSEMBLY

RELEASED
2016-06-16

APPROVED

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DRAWN	DB	EUGENE, OR	
CHECKED	WM	DRAWING NO.	REV. B
MFG. APPR.	DD	D4365	SHEET 3 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARBAR	NTS
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8 7 6 5 4 3 2 1